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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

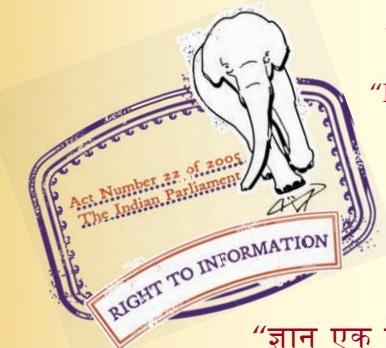
“Step Out From the Old to the New”

IS 6268 (1971): Accessories for Use in Shuttles for Plain Calico Looms [TXD 14: Machinery for Fabric Manufacture]

“ज्ञान से एक नये भारत का निर्माण”

Satyanaaran Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartṛhari—Nītiśatakam

“Knowledge is such a treasure which cannot be stolen”



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Indian Standard

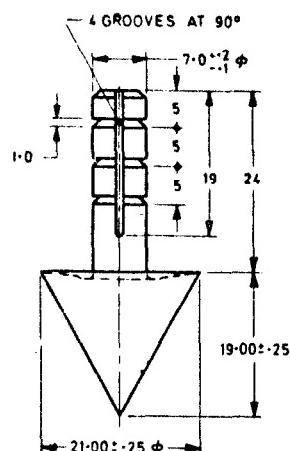
SPECIFICATION FOR ACCESSORIES FOR USE IN SHUTTLES FOR PLAIN CALICO LOOMS

1. Scope — Prescribed requirements of accessories, such as tip, tongue, plate clip, back spring, reinforcement ring, pot eye, peg and rest pin for use in shuttles for plain calico looms.

2. Requirements

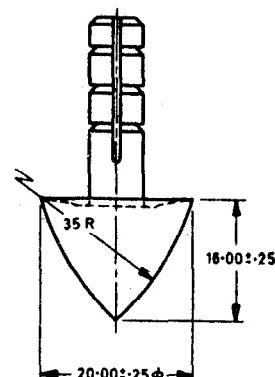
2.1 Tips — Made of bright steel rod conforming to the requirements of steel No. C35Mn75 or C45 of Schedule II of IS : 1570-1961 'Schedules for wrought steels for general engineering purposes'. The tips shall be any of the following three types:

- a) Sharp (see Fig. 1).
- b) Half blunt (see Fig. 2), and,
- c) Blunt (see Fig. 3).



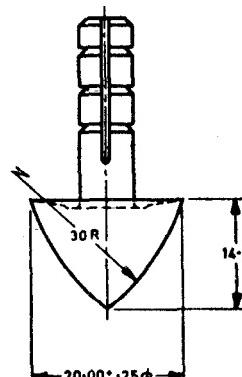
All dimensions in millimetres.

FIG. 1 A TYPICAL SHARP TIP



All dimensions in millimetres.

FIG. 2 A TYPICAL HALF BLUNT TIP



All dimensions in millimetres.

FIG. 3 A TYPICAL BLUNT TIP

Note — Dimensions of shank of Fig 2 and 3 are same as of Fig. 1.

2.1.1 Vickers hardness of approximately two-thirds of the cone (from the tip downwards) should be ranging between 520 and 590 when tested under a load of 30 kgf according to IS : 1501-1968 'Methods for Vickers hardness test for steel (first revision)'.

Note — Shank should be softer than the core.

2.2 Tongue — Any of the following types:

- a) Tongue with single spring (see Fig. 4),
- b) Tweezer plain tongue (see Fig. 5), and
- c) Tweezer collared tongue (see Fig. 6) made of mild steel wire.

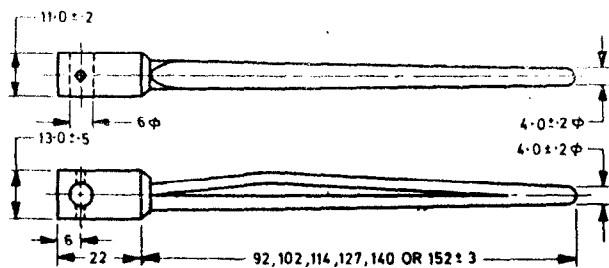


FIG. 4 A TYPICAL TONGUE WITH SINGLE SPRING

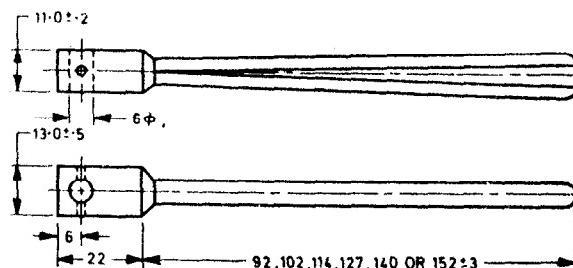


FIG. 5 A TYPICAL TWEEZER PLAIN TONGUE

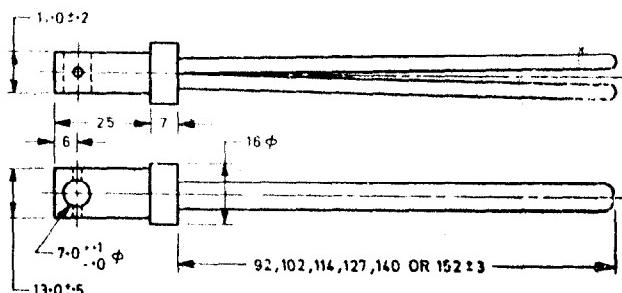


FIG. 6 A TYPICAL TWEEZER COLLARED TONGUE

Note — Oil holes on both sides should be provided enabling the user to use tongue on both sides.

2.3 Clip — Plate clip (see Fig. 7) or wire clip (see Fig 8).

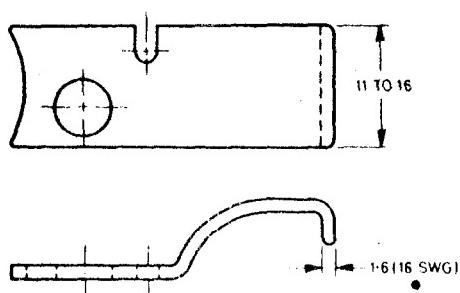


FIG. 7 A TYPICAL PLATE CLIP

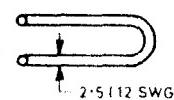


FIG. 8 A TYPICAL WIRE CLIP

2.3.1 *Plate clip* — Made of steel strip 11 to 16 mm wide and 1.60 mm (16 SWG) thick.

2.3.2 *Wire clip* — Made of steel wire 2.5 mm (12 SWG) thick.

2.4 Back Spring — Made of flat spring steel 9.5 mm wide and 1.6 mm (16 SWG) thick (see Fig. 9). The hardness of back springs shall be 40 HRC, Min when determined by the method prescribed in IS: 1586-1968 ' Methods for Rockwell hardness test (B and C scales) for steel (first revision) '.

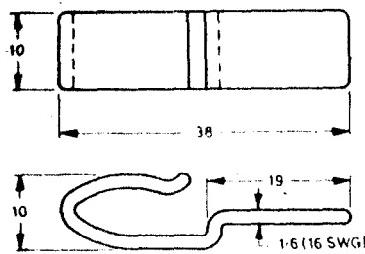
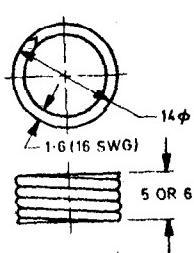


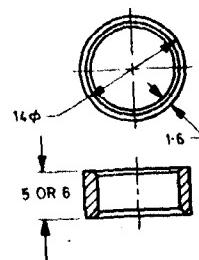
FIG. 9 A TYPICAL BACK SPRING

2.5 Reinforcement Ring — Wire ring (see Fig. 10) or solid ring with chamfer (see Fig. 11).



All dimensions in millimetres.

FIG. 10 A TYPICAL WIRE RING



All dimensions in millimetres.

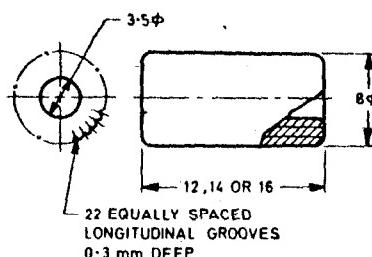
FIG. 11 A TYPICAL SOLID RING WITH CHAMFER

Note — Reinforcement ring is inserted in the body of the shuttle under the tip.

2.5.1 Wire ring — Made of tinned steel wire 1.6 mm (16 SWG) thick.

2.5.2 Solid ring with chamfer — Made of mild steel tube having thickness of 1.6 mm (16 SWG).

2.6 Pot Eye — Made of glazed porcelain with corrugations on outside. The ends of the pot eye shall be rounded (see Fig. 12).



All dimensions in millimetres.

FIG. 12 A TYPICAL POT EYE

2.7 Peg or Pin

2.7.1 Peg — Generally made of solid compressed wood or laminated wood.

2.7.2 Pin — Made of steel wire of the diameter prescribed by the buyer.

2.8 Rest Pin — Made of steel wire of the diameter prescribed by the buyer.

Note — One end of back spring (see 2.4) rests on this pin.

3. Marking — As far as possible, each item should be marked with the manufacturer's name, initials or trade-mark.

3.1 ISI Certification Marking — Details available from the Indian Standards Institution.